

Date Thursday, 16/08/2007 11:32:44 AM
User Linda Lacelle

Process Sheet

split 1

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT
 Job Number : 34027
 Estimate Number : 12577
 P.C. Number : *N/A*
 This Issue : 16/08/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : LARGE FAB ASSY
 Previous Run : 33580
 Part Number : D3562042
 Drawing Number : D3562 UNDER REVIEW
 Project Number : N/A
 Drawing Revision : A
 Material : *N/A*
 Due Date : 09/09/2007 Qty: *4* Um: *5* Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est Reva New Issue 06-11-09 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Qty Part # Description Batch:
 1 D2622-120C Extrusion *334016*

Check Material for any Dents or Defects

a.m 07.10.04 (5)

2.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:
 Qty Part Number Description Batch:
 2 D2734 End Cap *334485*

[Signature] 01.10.04 5

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562 *a.m 07.10.04* (5)

2-Deburr and bevel ends for welding *a.m 07.10.04* (5)

3-Weld (1)end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod

4-Grind end cap welds flush as per Dwg D3562

Updated on 9/8/07 by RE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 11:32:44 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 34027

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Job Number:



Seq. #: Machine Or Operation: Description :

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EN 7/10/16

5.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

N/A

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 02.10.04

5

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EN 7/10/04

8.0 D3560042 ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

ARM WELDMENT

B 34475

1/2 07.10.12 (2)

9.0 D3560044 ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

ARM WELDMENT

Batch: B34477

1/2 07.10.12 (2)

10.0 MS20600AD4W5 Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total: 180.0000 Each(s)

Blind Rivet

batch: M105125

1/2 07.10.12 (2)

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill Rivet holes as per dwg D3562.Touch up alodine.

a.m 02.10.12 (3) 1/2 07.10.12 (2)

PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
01-10-11	1	split w/o	HE	01-10-11	4		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 11:32:44 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 34027

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description:

Rivet legs using Magnabond as per dwg D3562.
Ensure to wipe off any excess magnabond of the step

Q.M. 07.10.12 (3)

A/R Magnabond 6398

Batch: *M104677*

K 07.10.12 (2)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Charles on Helicopter



Comment: INSPECT WORK TO CURRENT STEP

07/10/16 (5)

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod *M103794*

07.10.16 5

2-Grind end cap welds flush as per Dwg D3562

Q.M. 07.10.16

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-16 (5)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07/10/16 (5) (PTD) →

16.0

POWDER COATING

POWDER COATING



M105068



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.K. 07/10/17

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: *M105694*

FL 07/10/18 (5)

PTD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-10-24	#181	Put bushing D2808 # <u>B32896</u> on steps	mf lp	07-10-24	5			
07/10/24	#182	ingred QC #5	E	07/10/24	5		En 07/10/24	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/16	#	During inspection a foreign object was found in the step after the CAPS were welded.	05/10/12	Drill small hole to insert cap to remove foreign object	07-10-16	En 07/10/16	05/10/12	En 07/10/16
				Clear and remove debris	07-10-16			
				Re weld hole as per drawing	07-10-16			
		RC Human error	05/10/12	Re inspect bend QC #3	PD 07-10-16	En 07/10/16	05/10/12	En 07/10/16

NOTE: Date & initial all entries

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Drawing Name: STEP WELDMENT

Job Number: 34027

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-10-24

(17) See
Previous
Page

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

MM E 7/10/24 (5)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(5) 07/10/24

Job Completion



U 07-10-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

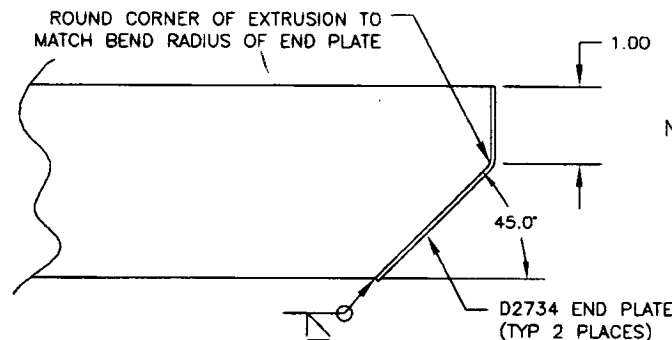
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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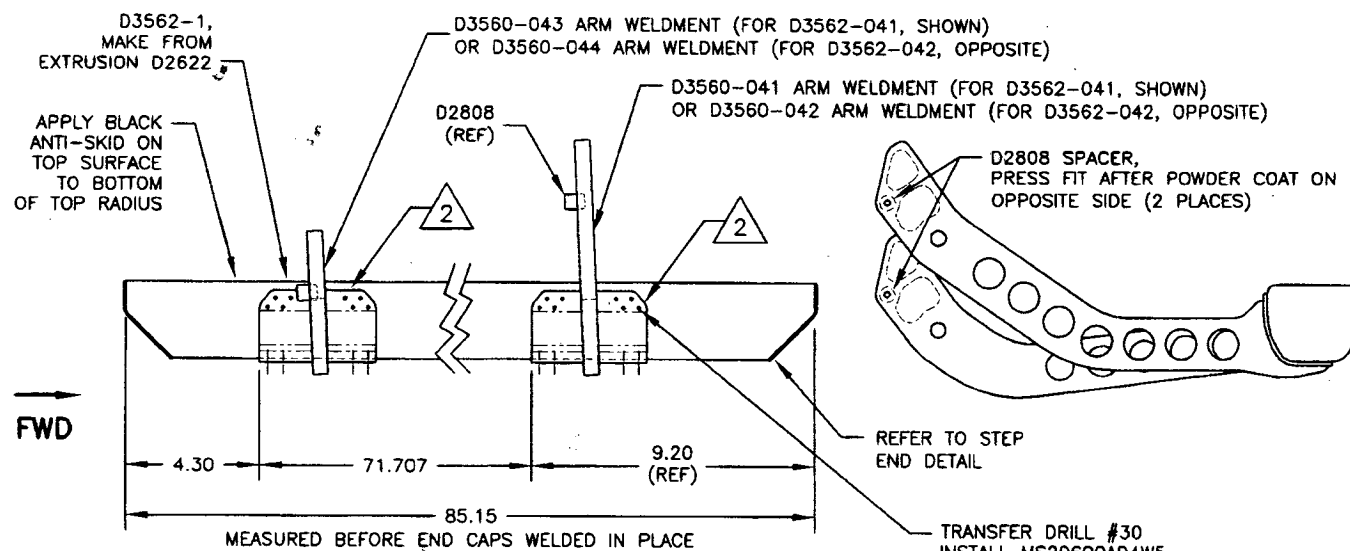
DART

RELEASED
07.06.21-10

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE



TRANSFER DRILL #30
INSTALL MS20600AD4W5
RIVET (32 PLACES),
DEBURR & TOUCH UP HOLES
WITH CHEMICAL CONVERSION
COAT BEFORE RIVETING

D3562-041 LH STEP ASSEMBLY (SHOWN)
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. C	
DATE		TITLE	SHEET 1 OF 1	SCALE
07.06.19		STEP ASSEMBLY	NTS	
A	06.09.26	NEW ISSUE		
B	07.01.15	ARMS NOW RIVETED TO STEP		
C	07.06.19	NOW MAGBND, ADD D2808, RMV 4 RVTS		

2/0 34027